

Date: Thursday, 7/26/2007 9:49:10 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING ASSEMBLY
Job Number	: 33736		
Estimate Number	: 11136		
P.O. Number	: <i>N/A</i>	Part Number	: D3183045
This Issue	: 7/26/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3183 REV C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : MACHINED PARTS	Drawing Revision	: C1
Previous Run	: 31762	Material	: <i>N/A</i>
Written By	:	Due Date	: 8/2/2007 Qty: 30 Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.07.26		
Comment	: Est A 04.02.18 New issue KJ/DS		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELINR1000	Delrin Round Bar 1"
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Comment: Qty.: 0.0350 f(s)/Unit Total : 1.0490 f(s)  
 Delrin Round Bar 1"  
 Material: Ø1.00 Delrin Rod  
 (M-DELRIN-R1.000)  
 Identify as D3183-9  
 Batch: *M104346* *DJP 07/08/18*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL  
 Turn D3183-9 Cap as per Folio FA388  
 Deburr

*DJP 07/08/18* *(60)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DJP 07/08/18* *(60)*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*J.L 07/08/19*

5.0	D31835	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1

D3183-5

Bearing

*B33783 x28*

*in 07/09/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/10

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/26/2007 9:49:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 33736

Part Number: D3183045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

*ml 07/09/10 x28*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*count  
in 07/09/10 (x28)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*32 x ~~D3183~~  
D3183-9 go in stock w  
7/8/10 (28x) SP*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/09/10*

Job Completion



*U 57-89-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

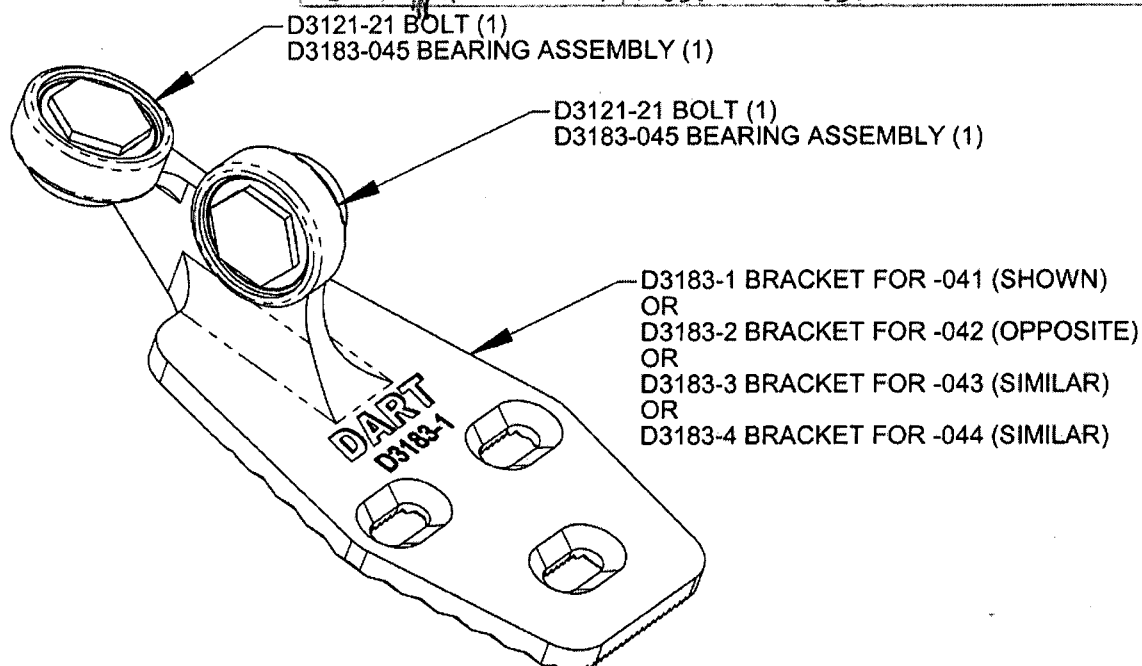
NOTE: Date & initial all entries



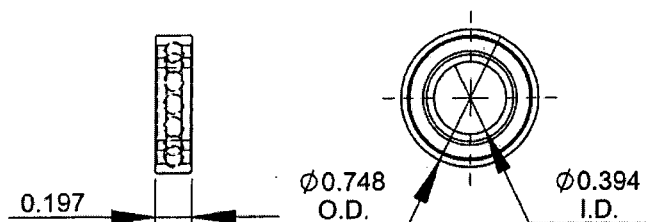


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CHECKED #	APPROVED #	DRAWING NO. <b>D3183</b>	REV. C SHEET 1 OF 4
DATE <b>04.02.17</b>	TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1	
A.	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	<del>04.11.09</del>	0.830 WAS 0.850	

RELEASED  
04.03.01



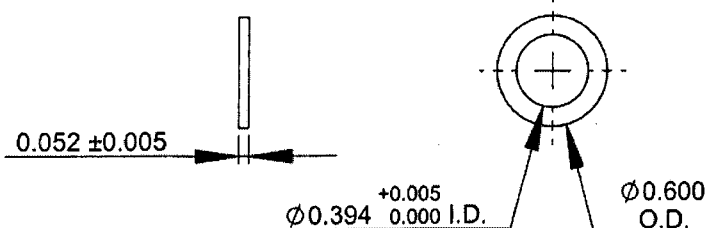
**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**



**D3183-5 BEARING:**  
**SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

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**D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

WORK ORDER  
NO. 33736

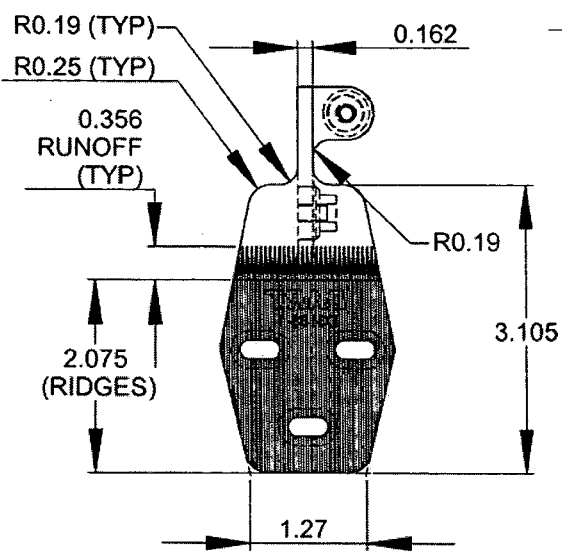
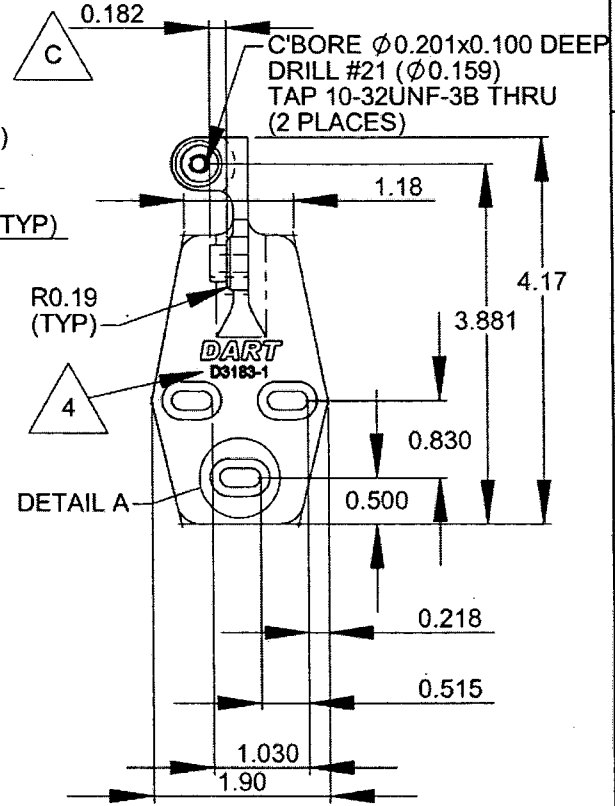
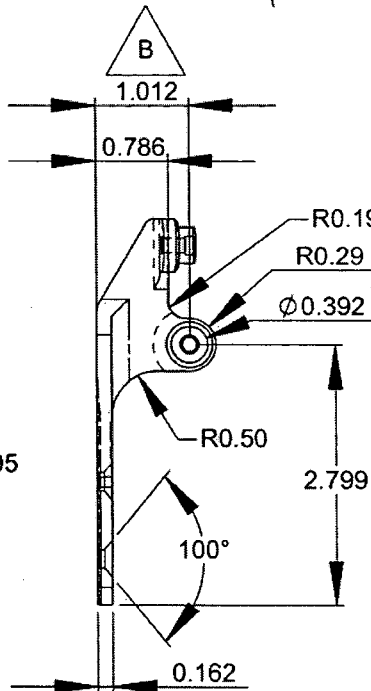
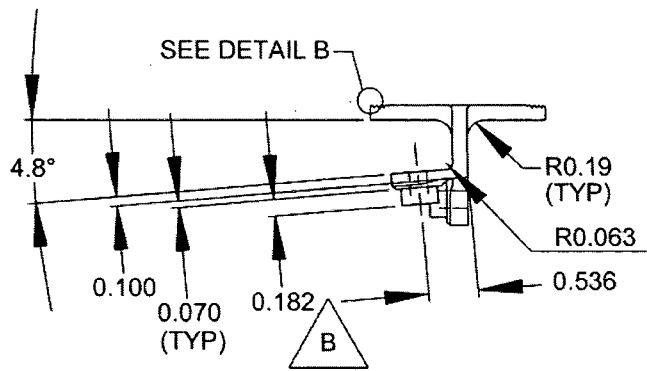
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DATE 04.02.17	DRAWING NO. D3183	REV. C
	TITLE BRACKET ASSEMBLY	SHEET 2 OF 4
		SCALE 1:2

RELEASED  
04-03-01



D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

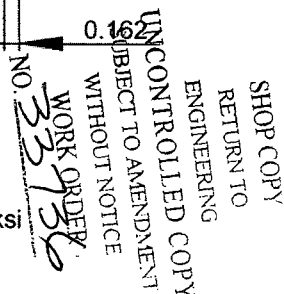
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		D3183	SHEET 3 OF 4
DATE	TITLE		SCALE
04.02.17	BRACKET ASSEMBLY		1:2



1) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi

2) BREAK ALL SHARP EDGES 0.005 TO 0.015

3) ENGRAVE DART P/N & LOGO AS SHOWN

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

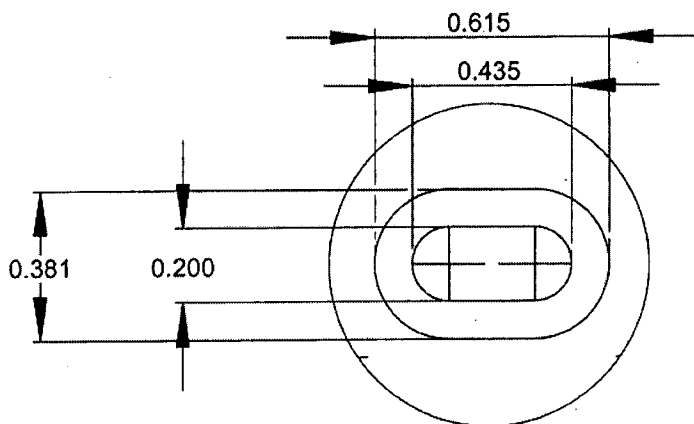
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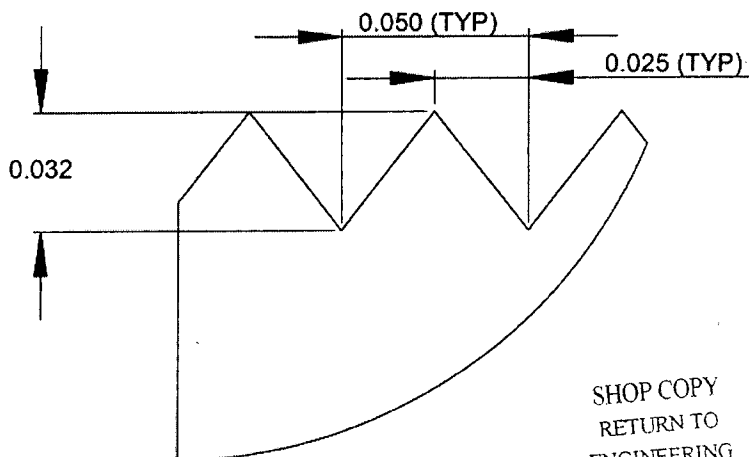


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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



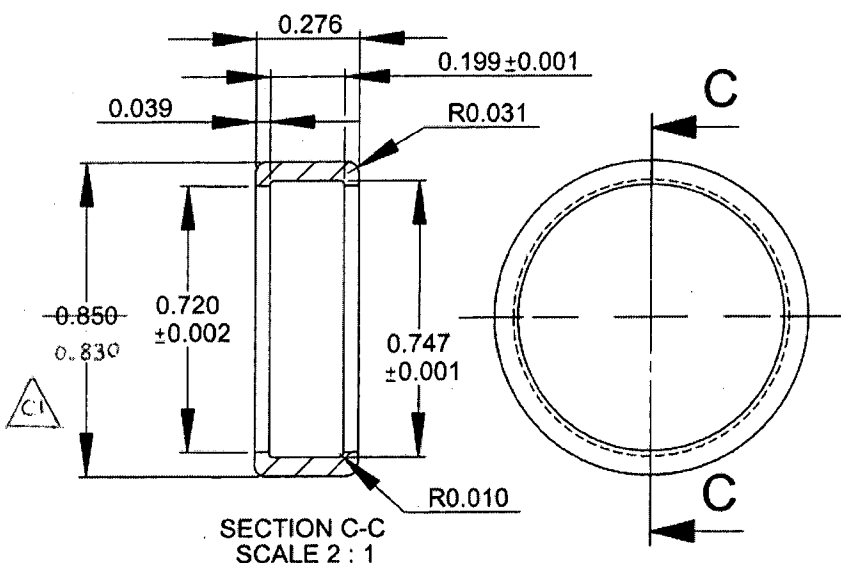
DETAIL A (2 : 1)

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04.03.01 *[Signature]*



DETAIL B (20 : 1)

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NO. 33736



**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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